

Tuesday, May 26, 2015 12:44:15 PM

Page 1

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 133102

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133102

Page 2

Item ID: D2891-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support 2.25
Start Date: 5/26/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 5/26/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						10			DAS 41 9-89
HandFXtube	Memo	0.00							156-23
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 132391								
140	QC3- Inspect Part Finish	0.00							
140						10			DAS 27 9-89
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>LG052</u>	0.00							
170						10x			DAS 26 9-89
Packaging	Memo	0.00							
Packaging	LOCATION : LG052								JUN 24 2015

JUN 23 2015

DQA: _____ Date: _____



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Work Order update only ☐

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Work Order ID 133102***133102***

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Item ID: D2891-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support 2.25
Start Date: 5/26/15 Start Qty: 10.00 ***10*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

MLJ JUN 24 2015

MLJ JUN 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐																					

Picklist Print

Tuesday, May 26, 2015 12:44:15 PM

Page 1

Work Order ID: 133102

133102

Parent Item: D2891-1

D2891-1

Parent Item Name: Support 2.25

Start Date: 5/26/15

Required Date: 5/26/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP C02.11.26Added P/OKJ

IPP D*08.03.19 Re-format EC verified: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSK076

Manufactured

No

110

Each

2.0000

0.5

5

DSK076

D2891-1 Turning Detail

[Signature]
15/06/18

Location

Loc Qty

Loc Code

MAT060

119736

2

2

2

133137 3

2
3

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 133102
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.190	0.190	0.190	0.196	0.190
AB	0.240	0.260		0.244	0.246	0.249	0.246	0.253
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060		0.051	0.051	0.051	0.051	0.051
AE	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.132	0.132	0.132	0.132	0.132
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.041	1.041	1.041	1.042	1.040
AM	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AN	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AO	1.663	1.683		1.676	1.676	1.677	1.677	1.676
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.031	0.031	0.031	0.031	0.031
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>[Signature]</i>	Date: 15/06/15
Audited by: <i>[Signature]</i>	Date: 15/06/22
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	133/02
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

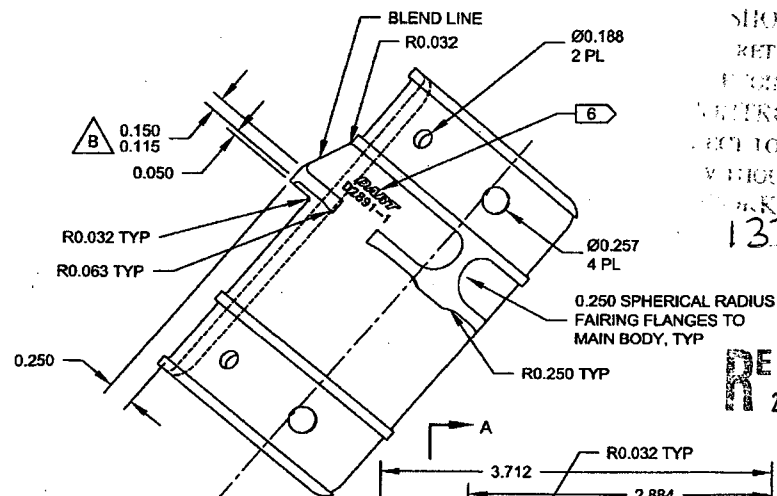
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.243	0.241	0.242	0.242	0.242
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060		0.051	0.051	0.051	0.051	0.051
AE	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.140	0.140	0.138	0.138	0.138
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.042	1.040	1.042	1.040	1.042
AM	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AN	0.257	0.262		0.259	0.259	0.259	0.259	0.259
AO	1.663	1.683		1.679	1.663	1.664	1.676	1.676
AP	0.053	0.073		0.062	0.062	0.062	0.062	0.062
AQ	0.022	0.042		0.031	0.031	0.031	0.031	0.031
AR								
AS								
AT								
Accept/Reject								

Measured by:	<i>[Signature]</i>	Date:	15/06/15
Audited by:	<i>[Signature]</i>	Date:	15/06/22
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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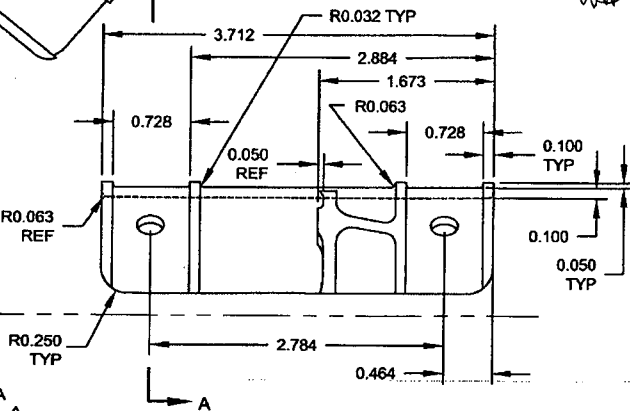
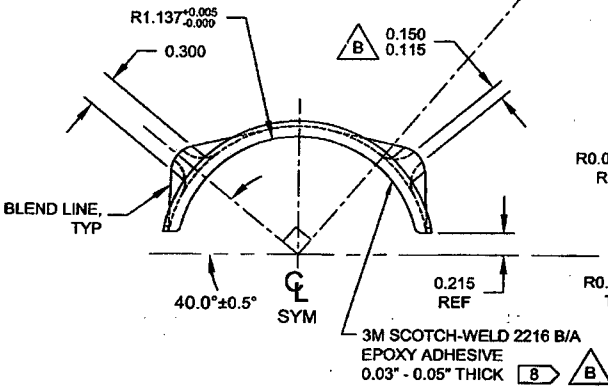
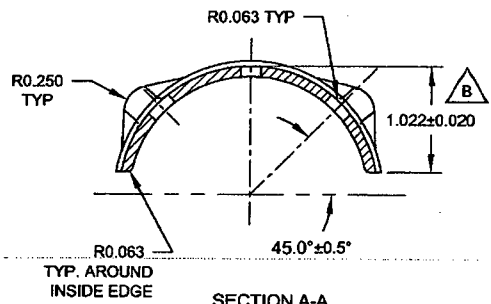
NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.38 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT), APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



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13310.2 MJS
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JAN



D2891-1 SUPPORT

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D4-1,B4-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2891
TITLE Ø2.250 SUPPORT
REV. B
SHEET 1 OF 1
SCALE NTS

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